

Work Order ID 61650

Tuesday, August 31, 2010 9:49:47 AM



Page 1

Item ID: D3500-1

Revision ID:

Item Name: Saddle

Start Date: 8/31/2010

Start Qty: 1.00

Required Date: 9/7/2010

Req'd Qty: 1.00

Accept



Setup

Start



Stop



25 W



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: M Date: 10-8-31 Tooling: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

SL 10/09/30

(25)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

SL 10/09/30

25 Ø

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

25 Ø

Work Order ID 61650

Tuesday, August 31, 2010 9:49:47 AM



Page 2

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



HandFinish

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

=> M 10/10/00

Tool ID

0.00

Tool #

0.00

Plan
Code

0.00

Accept
Qty

0.00

Reject
Qty

0.00

Reject
Number

0.00

Insp.
Stamp

140



Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

M 10/10/00

Memo

0.00

10/10/00

0.00

oven temperature:

START TIME: 10:25 FINISH TIME: 10:55

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/10/00

0.00

memo

25 0

Work Order ID 61650

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Tuesday, August 31, 2010 9:49:47 AM

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionIdentify as per dwg & Stock Location: 424Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

Tuesday, August 31, 2010 9:49:52 AM

Page 1

Work Order ID: 61650



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 		Manufactured	No			100	Each	11.0000	1			10/09/23	

Saddle Billet

Location	Loc Qty	Loc Code
MAT43	11	
59467	3	
60713	8	
61300	26	<u>25</u>

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488	DTP-II	Vern
B	1.175	1.185		1.180	1.180	1.180	1.180	"	"
C	3.145	3.155		3.150	3.150	3.150	3.150	"	"
D	1.175	1.185		1.180	1.180	1.180	1.180	"	"
E	0.365	0.385		0.385	0.380	0.380	0.380	"	"
F	0.490	0.510		0.499	0.499	0.499	0.499	"	"
H									
I	R1.575	R1.595		1.5845	1.5895	1.5885	1.588	Dial	
J	0.240	0.260		0.248	0.248	0.248	0.248	DTP-II	Vern
K	0.490	0.510		0.499	0.500	0.499	0.500	"	"
L	3.590	3.650		3.620	3.620	3.620	3.620	"	"
M	0.315	0.322		0.318	0.318	0.318	0.318	"	"
N	0.256	0.262		0.260	0.260	0.260	0.260	"	"
O	6.500	6.520		6.510	6.510	6.510	6.510	CNC-02	Vern
P	5.990	6.010		5.995	5.995	5.995	5.995	"	"
Q	2.820	2.830		2.825	2.825	2.825	2.825	DTP-II	Vern
R	2.495	2.505		2.500	2.500	2.500	2.500	"	"
S	2.245	2.255		2.250	2.250	2.250	2.250	"	"
T	1.120	1.130		1.125	1.125	1.125	1.125	"	"
U	0.540	0.560		0.545	0.545	0.547	0.547	"	"
V	0.793	0.803		0.798	0.798	0.798	0.798	N/A	
W	R.240	R.260		0.250	0.250	0.250	0.250	Rad Gage	
X	0.040	0.060		0.060	0.060	0.060	0.060	DTP-II	Vern
Y	0.100	0.120		0.110	0.110	0.110	0.110	"	"
AA	R1.125	R1.145		1.1345	1.1375	1.136	1.136	Dial	
AB	R.490	R.510		0.500	0.500	0.500	0.500	Rad Gage	
AC	0.615	0.635		0.635	0.635	0.635	0.635	DTP-II	Vern
AD	0.240	0.260		0.253	0.253	0.253	0.253	"	"
AE	1.810	1.830		1.821	1.827	1.827	1.827	"	"
AF	0.240	0.260		0.251	0.252	0.251	0.251	DTP-02	Mic
AG	0.140	0.160		0.150	0.152	0.151	0.151	"	"
AH	0.140	0.160		0.155	0.148	0.148	0.148	1B-100	Deep Mic
AI	0.140	0.160		0.158	0.154	0.155	0.155	"	"
Accept/Reject									

Measured by:	DTP	Audited by:	K.A
Date:	10/09/23	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	28/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

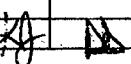
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

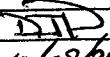
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.498	0.499	0.498		
H									
I	R1.575	R1.595		1.588	1.588	1.587	1.5885		
J	0.240	0.260		0.247	0.248	0.248	0.248		
K	0.490	0.510		0.499	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.2600	0.2600	0.2600	0.2600		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.995	5.995	5.995		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.545	0.545		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.060	0.060	0.060	0.060		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.1355	1.135	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.252	0.253	0.253	0.253		
AE	1.810	1.830		1.827	1.827	1.827	1.826		
AF	0.240	0.260		0.251	0.250	0.250	0.251		
AG	0.140	0.160		0.151	0.150	0.150	0.151		
AH	0.140	0.160		0.150	0.148	0.149	0.150		
AI	0.140	0.160		0.153	0.156	0.155	0.156		
Accept/Reject									

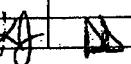
Measured by:		Audited by:	
Date:	10/09/24	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.584	1.586	1.587	1.587		
J	0.240	0.260		0.247	0.248	0.247	0.249		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.995	5.995	5.995	5.995		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.543	0.543	0.545	0.544		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.139	1.135	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.253	0.251	0.252		
AE	1.810	1.830		1.826	1.826	1.825	1.826		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		0.150	0.151	0.150	0.151		
AH	0.140	0.160		0.150	0.149	0.148	0.148		
AI	0.140	0.160		0.155	0.157	0.156	0.154		
Accept/Reject									

Measured by:		Audited by:	
Date:	10/09/21	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.499	0.500	0.500		
H									
I	R1.575	R1.595		1.587	1.587	1.587	1.586		
J	0.240	0.260		0.247	0.247	0.247	0.248		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.998	6.000	5.998		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.545	0.544	0.543		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.135	1.136	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.252	0.251	0.251		
AE	1.810	1.830		1.826	1.826	1.825	1.825		
AF	0.240	0.260		0.251	0.251	0.250	0.250		
AG	0.140	0.160		0.151	0.152	0.150	0.150		
AH	0.140	0.160		0.149	0.150	0.150	0.150		
AI	0.140	0.160		0.156	0.153	0.154	0.154		
Accept/Reject									

Measured by:	<u>DJP</u>	Audited by:	<u>H.A</u>
Date:	10/09/28	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<u>KJ</u> <u>DA</u>

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.380	0.380	0.380	0.380		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.5866	1.586	1.586	1.587		
J	0.240	0.260		0.247	0.247	0.248	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	0.318	0.318	0.318		
N	0.256	0.262		0.260	0.260	0.260	0.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.998	5.998	5.996	5.996		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.545	0.543	0.543	0.543		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.135	1.135	1.136	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.810	1.830		1.825	1.825	1.825	1.826		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.149	0.153	0.149	0.149		
AI	0.140	0.160		0.153	0.155	0.153	0.153		
Accept/Reject									

Measured by:		Audited by:	
Date:	10/09/28	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

DART AEROSPACE LTD				Work Order:	61650
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.488	0.488	0.488	0.488		WPSN JL3
B	1.175	1.185		1.180	1.180	1.180	1.180		"
C	3.145	3.155		3.150	3.150	3.150	3.150		"
D	1.175	1.185		1.180	1.180	1.180	1.180		"
E	0.365	0.385		0.380	0.380	0.380	0.380		"
F	0.490	0.510		.501	.502	.502	.501		"
H									
I	R1.575	R1.595		1.587	1.588	1.589	1.588	Dial	
J	0.240	0.260		.251	.250	.250	.251	Vern JL3	
K	0.490	0.510		.502	.502	.502	.500	"	
L	3.590	3.650		3.620	3.620	3.620	3.620	"	
M	0.315	0.322		0.318	0.318	0.318	0.318	"	
N	0.256	0.262		0.260	0.260	0.258	0.258	"	
O	6.500	6.520		6.510	6.510	6.509	6.510	"	
P	5.990	6.010		5.998	5.998	5.998	5.998	"	
Q	2.820	2.830		2.825	2.825	2.825	2.825	"	
R	2.495	2.505		2.500	2.500	2.500	2.500	"	
S	2.245	2.255		2.250	2.250	2.250	2.250	"	
T	1.120	1.130		1.125	1.125	1.125	1.125	"	
U	0.540	0.560		.544	.546	.548	.547	"	
V	0.793	0.803		0.798	0.798	.798	.798	"	
W	R.240	R.260		0.250	0.250	.250	.250	R-G	
X	0.040	0.060		.050	.050	.050	.050	Vern JL3	
Y	0.100	0.120		.110	.110	.110	.110	"	
AA	R1.125	R1.145		1.135	1.135	1.136	1.136	dial	
AB	R.490	R.510		0.500	0.500	.500	.500	R-G	
AC	0.615	0.635		0.635	0.635	.635	.635	Vern JL3	
AD	0.240	0.260		.253	.255	.253	.253	"	
AE	1.810	1.830		1.825	1.826	1.825	1.826	"	
AF	0.240	0.260		0.250	0.251	.251	.252	"	
AG	0.140	0.160		0.150	0.150	.150	.149	"	
AH	0.140	0.160		.150	.151	.151	.151	"	
AI	0.140	0.160		.153	.154	.152	.153	"	
Accept/Reject									

Measured by:	DJL	/	JL	Audited by:	H.A
Date:	10/09/29	/	10/09/30	Date:	10/09/30

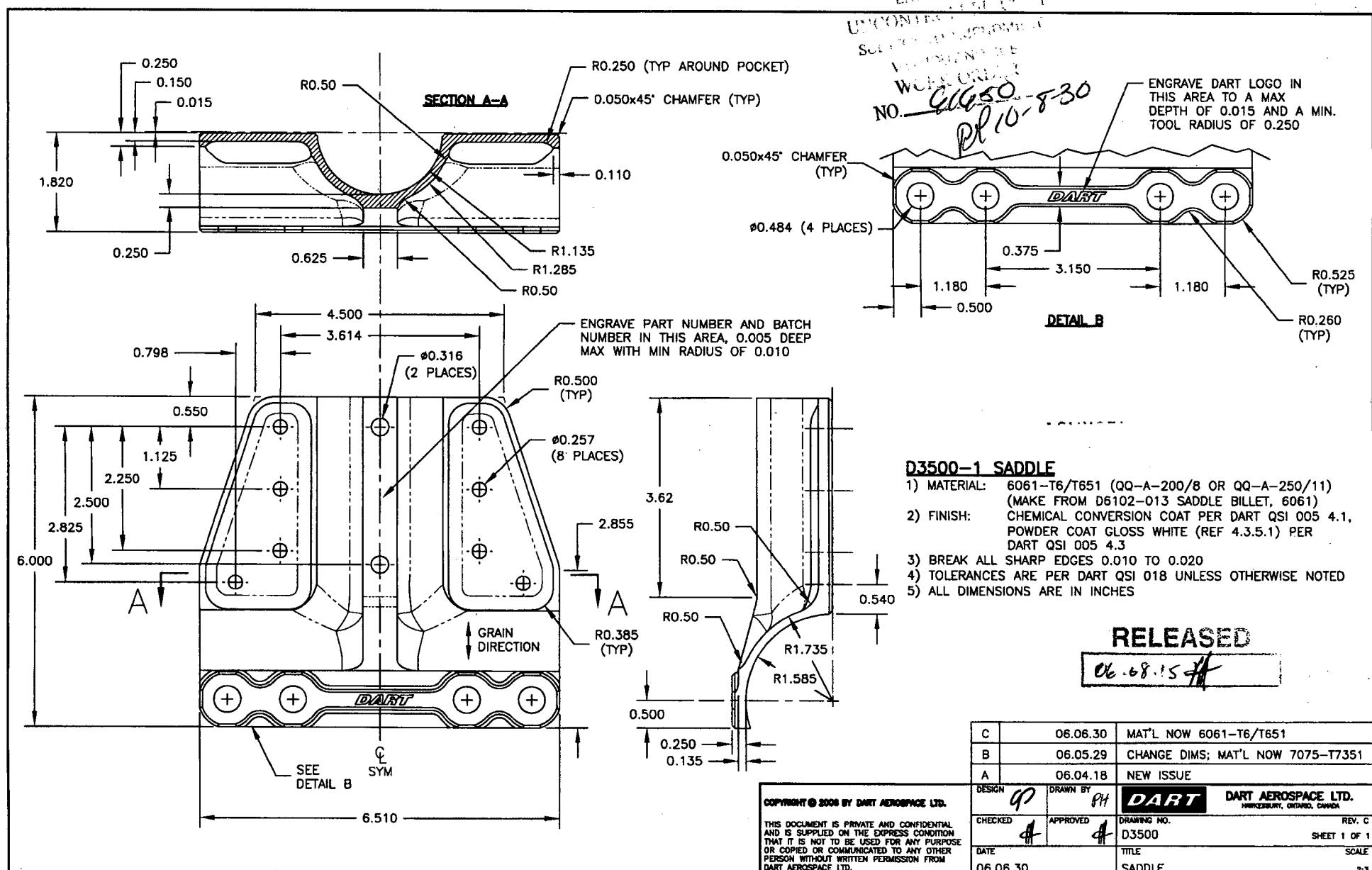
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	JK AB

DART AEROSPACE LTD		Work Order:	61650
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	25	2	3	4	By	Date	
A	0.483	0.490		.488						
B	1.175	1.185		1.180						
C	3.145	3.155		3.150						
D	1.175	1.185		1.180						
E	0.365	0.385		.380						
F	0.490	0.510		.502						
H										
I	R1.575	R1.595		1.587						
J	0.240	0.260		.250						
K	0.490	0.510		.502						
L	3.590	3.650		3.620						
M	0.315	0.322		.318						
N	0.256	0.262		.260						
O	6.500	6.520		6.510						
P	5.990	6.010		5.998						
Q	2.820	2.830		2.825						
R	2.495	2.505		2.500						
S	2.245	2.255		2.250						
T	1.120	1.130		1.125						
U	0.540	0.560		.547						
V	0.793	0.803		.798						
W	R.240	R.260		.250						
X	0.040	0.060		.050						
Y	0.100	0.120		.110						
AA	R1.125	R1.145		1.134						
AB	R.490	R.510		.500						
AC	0.615	0.635		.635						
AD	0.240	0.260		.252						
AE	1.810	1.830		1.825						
AF	0.240	0.260		.249						
AG	0.140	0.160		.149						
AH	0.140	0.160		.150						
AI	0.140	0.160		.153						
Accept/Reject										

Measured by:	<u>JK</u>	Audited by:	<u>K.A</u>
Date:	10/09/36	Date:	10/09/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<u>JK</u> <u>DA</u>



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries